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D2739**Job Sheet 201249****Part No:** D2739**Job Qty:** 4 pcs**Part Name:** 350 I-Beam**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/27/19**Job Tracking No:****Due Date:** 10/21/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD ver: EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	10/21/19		0.00	2.16	Skidtubes - 1		JW
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs	10/21/19		0.00	0.00	QC 5 - 10		BE MAA
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Handfinish - 1-1 Chemical-B4B	4 pcs	10/21/19		0.00	0.33	Handfinish - 1 - 1 - B4B		BE 19-10-09
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

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				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	4 pcs	10/21/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81

140 Packaging 3-1 - Stock - B4B	4 pcs	10/21/19	0.00 0.00	QC 7 - 76	29
				Packaging 3 - 1 - B4B	20
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - (Skid tubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

110 - QC5- Inspect part completeness to step on W/O

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7- Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location:) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	4 pcs (1 ea)	100-Skid tubes - 1	S146203

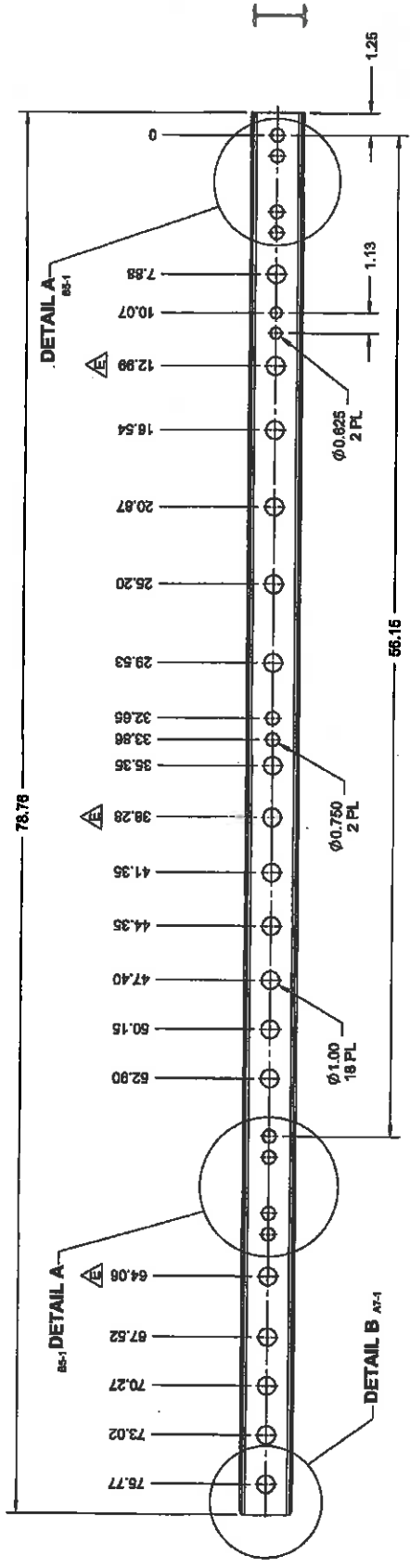
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skid tubes - 1	D2600-5-108	4	170	0

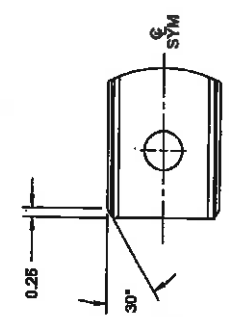
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220		
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850		
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040		
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960		
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510		
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840		
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170		
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500		
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620		
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830		
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320		
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250		
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320		
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320		
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370		
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120		
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870		
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030		
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240		
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990		
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740		
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120		

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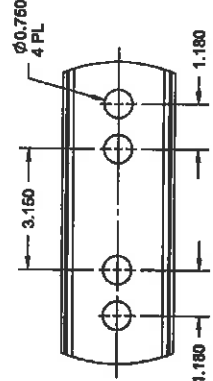
8 7 6 5 4 3 2 1



D2739 WEB



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

RELEASED
R 2010-11-01

REV.	DESCRIPTION	DATE
E	ADD REMOVE HOLES FOR D164 WEARPLATE. 38.28 WAS 39.35 (DS-1) 64.06 WAS 64.77 (DS-1). ADD HOLE (DS-1)	10.10.08
D	ADD BEVEL TO FWD END. ADD DETAIL B	07.06.29
C	ADD REMOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUSER	06.11.18
A	NEW ISSUE	06.04.16
DESIGN	DS	BY
DRAWN		
CHECKED		
MFG. APPR.		
DE APPR.		
DATE	10.10.08	

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	D2739
TITLE	WEB
SCALE	NTS
SHEET 1 OF 1	

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-S EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART PIN "D2739" AND BIN PER DART QSI 044 8.1
 - 7) WEIGHT: 3.41 lbs

